

# Work Order ID 84063

May-02-12 11:48:35 AM

**\*84063\***

Page 1

Item ID: D2432

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: 206 (24") Bearpaw

Start Date: 5/02/12 Start Qty: 12.00

**\*12\***

Cust Item ID:


Required Date: 5/11/12 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00

**\*120\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

UHMW 1" Blk

130

0.00

**\*130\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio and Dwg D2432 Identify as D2432F  
3-Deburr

140

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*140\***

QC

Memo

0.00

Quality Control

B12-5-6

FT 12-07-03 (9)

CS 12-07-03 (9)

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Page 2

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Start Date: 5/02/12 Start Qty: 12.00

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**\*12\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC8- Inspect parts - second check

0.00

**\*150\***

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*151\***

Packaging

Memo

PP086 336

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

OK 12/07/10 4

9 0

Pen 1/6 (9)

OK 12/7/10  
MF  
12-07-06

# Picklist Print

May-02-12 11:48:34 AM

Page 1

Work Order ID: 84063  
Parent Item: D2432  
Parent Item Name: 206 (24") Bearpaw

Start Date: 5/02/12  
Start Qty: 12.00

Required Date: 5/11/12  
Required Qty: 12.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	231.2100	3.7	44.4			
UHMW 1" Black													

### Location

### Loc Qty

### Loc Code

MAT018

30.1

120972

3

121346

27.1

MAT019

1.5

118814

1.5

ST052

199.6099947

121277

12.8

121278

186.809995

121278

RD-5-6

(9)



DESIGN <b>KE</b>	DRAWN BY <b>KE</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>MPK</b>	APPROVED <b>SA</b>	DRAWING NO. D2432	REV. F SHEET 1 OF 2
DATE 98.05.12	TITLE BEARPAW	SCALE 1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

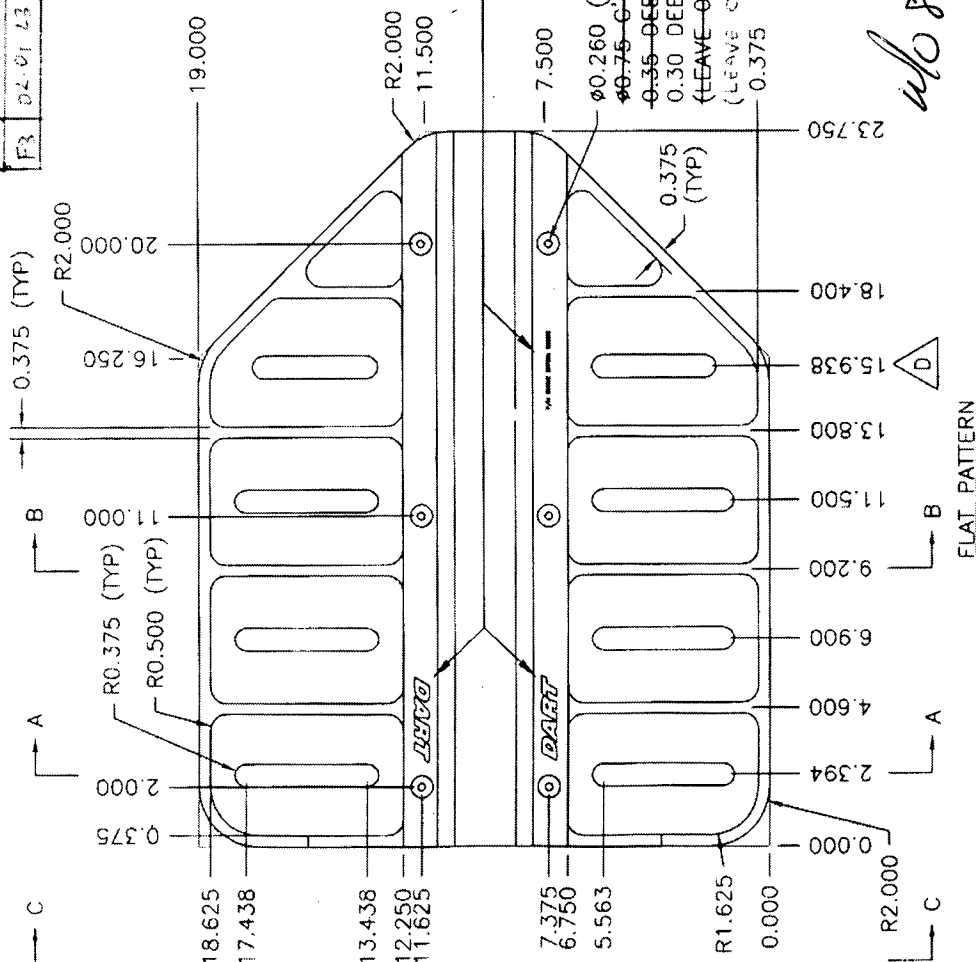
RELEASED  
49.06.17 KE

ENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)

EFFECTIVE DEUS

9143

F1	98.05.12	ADD DEC 9143
F2	98.05.28	REV 1 WAS 9070
F3	02.01.13	CLARIFY BORE PMS



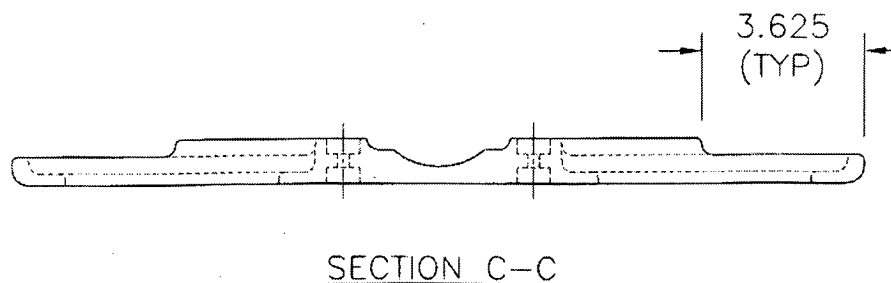
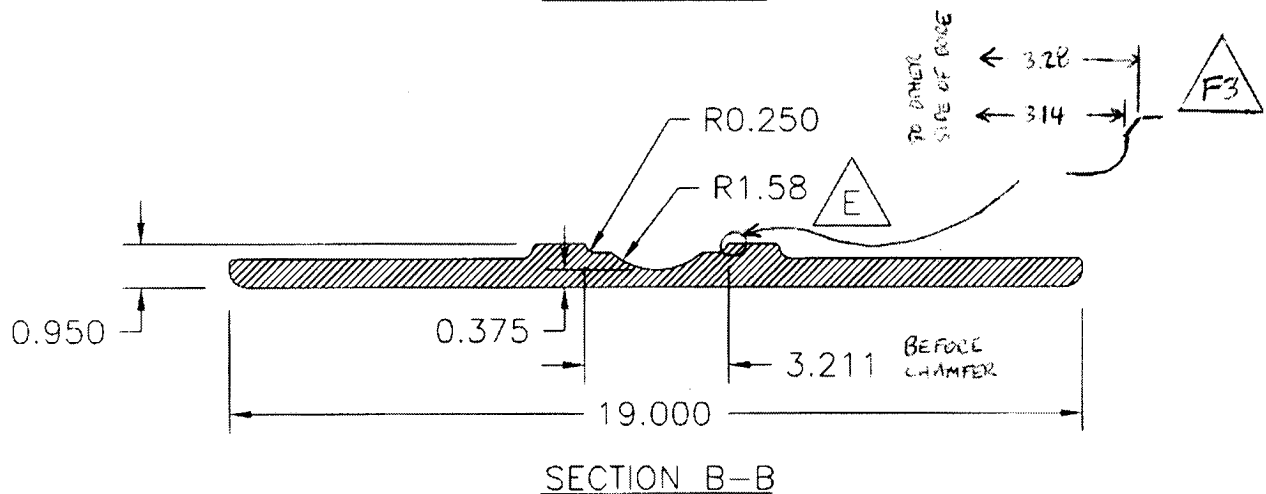
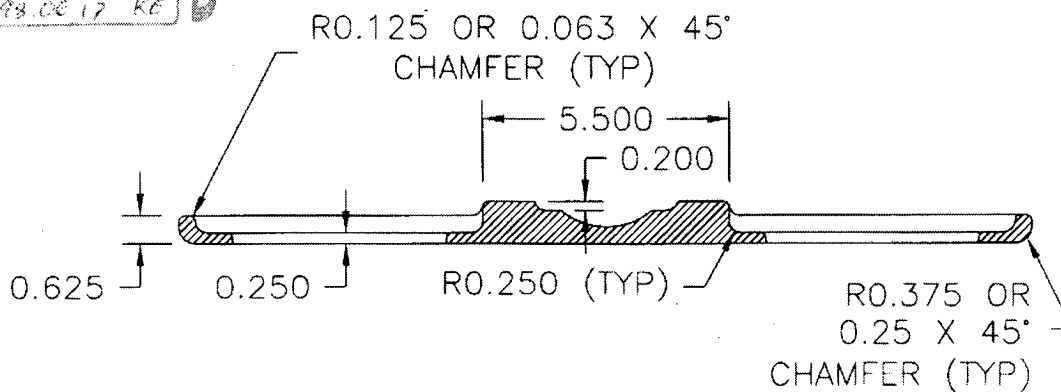
D2432E: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED P.P.	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 84063	
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2432	
<b>Inspection Dwg:</b> D2432 <b>Rev:</b> F3		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                 
 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.053	✓		ven	RT-4
B	5.500	+/-0.030	5.500	✓		"	
C	0.200	+/-0.030	.212	✓		depth gauge	RT-6
D	0.25 x 45°	+/-0.030	.250	✓		ven	RT-4
E	R0.250	+/-0.030	.250	✓		red gauge	
F	0.250	+/-0.010	.254	✓		ven	
G	0.625	+/-0.030	.627	✓		"	
H	0.375	+/-0.010	.374	✓		"	
I	0.950	+0.030/0.010	.966	✓		"	
J	19.000	+/-0.030	19.000	✓		Tape	RT-10
K	3.14	+/-0.030	3.125	✓		ven	
L	3.28	+/-0.030	3.298	✓		"	
M	Ø0.260	+0.005/-0.000	.260	✓		"	
N	Ø0.93	+/-0.030	.926	✓		"	
O	0.30	+0.030/-0.000	.305	✓		"	
P	23.750	+/-0.030	23.750	✓		Tape	RT-10
Q	7.375	+/-0.030	7.375	✓		"	
R	4.250	+/-0.010	4.252	✓		ven	RT-4
S	2.000	+/-0.030	1.996	✓		"	
T	9.000	+/-0.010	9.000	✓		Tape	RT-10
U	9.000	+/-0.010	9.000	✓		"	
V	0.375	+/-0.010	.378	✓		ven	RT-4

<b>Measured by:</b> RT	<b>Audited by:</b> gmf	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12-07-03	<b>Date:</b> 12/07/04	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue      P/O K10008/D206-559-015	KJ/RF	RT